

Work Order ID 66836

Monday, February 28, 2011 11:42:16 AM



Page 1

Item ID: D2587

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Slug, 350 Hinge

Start Date: 2/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

1-02-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2587	Rev A1								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2587 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-

Deburr if necessary

6061 .040

HB11-3-4

28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB11-3-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suloslog

counters
(128)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130.

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

= 7m, 11/03/04

(28X)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

28X 11/03/04

150

Identify as per dwg & Stock Location 17

0.00



Packaging

Memo

0.00

Packaging

11/3/11 28X

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11
ME
11-03-07

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, February 28, 2011 11:42:23 AM

Page 1

Work Order ID: 66836

Parent Item: D2587

Parent Item Name: Door Slug, 350 Hinge



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ D ☐ 04.05.31 ☐ Step 2 changed ☐ KJ/JLM ☐
IPP ☐ E ☐ 06.07.31 ☐ Waterjet ☐ EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 		Purchased	No			100	sf	42.4300	0.016	0.336842	15		
6061-T6 .040 Sheet											181-3-2		

Location

Loc Qty

Loc Code

MAT21

42.43

111224

0.4

113004

42.03

113004

(28)

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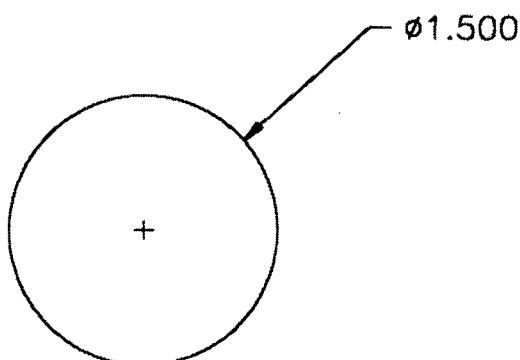
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED <i>M. M.</i>	APPROVED <i>M. M.</i>	D2587	SHEET 1 OF 1
DATE 96:07:11	TITLE DOOR SLUG		SCALE 1:1
AI <i>KJH</i> 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66834

PH11-02-25

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B)

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ETCH, ALODINE

W/O:		WORK ORDER CHANGES						
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